

Shy ay/db

# Work Order ID 57380

April 6, 2010 9:00:40 AM

Page 1

Item ID: ERA-N500EH-RH

Accept

Revision ID:

Item Name: Instrument panel, RH

Start Date: 4/06/10 Start Qty: 1.00

Required Date: 4/06/10 Req'd Qty: 1.00

Reference:

Approvals:

Process Plan: *W*

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Draw  
Number

Draw  
Rev.

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

Memo

0.00

FLOW CNC Waterjet

cut per drwg

*1B 10-4-6*

*(1)*

110

QC2- Inspect parts off machine FAI/FAIB

0.00



QC

Memo

0.00

Quality Control

*1B 10-4-6*

120

QC8- Inspect parts - second check

0.00



QC

Memo

0.00

Quality Control

*S. Soler 4/6*

*(X)*

**Work Order ID 57380**

April 6, 2010 9:00:41 AM



Page 2

Item ID: ERA-N500EH-RH

Accept



Setup Start



Revision ID:

Stop



Item Name: Instrument panel, RH

Start Date: 4/06/10 Start Qty: 1.00



Cust Item ID:

Required Date: 4/06/10 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop



QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursDraw  
NumberDraw  
Rev.Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

130

0.00



Packaging

Memo

0.00

Packaging

id &amp; stk

U 10-04-06

140

0.00



QC

QC21- Final Inspection - Work Order Release

Memo

0.00

Quality Control

10/04/06 J

U 10-04-06

# Picklist Print

April 6, 2010 9:00:40 AM

Page 1

Work Order ID: 57380

Parent Item: ERA-N500EH-RH

Parent Item Name: Instrument panel, RH

Start Date: 4/06/10

Required Date: 4/06/10

Comments:

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M6061T6S.125		Purchased	No				sf	130.0000	2.4000			



6061-T6 .125 Sheet



1310-4-6

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT21	130	
112476	24	
113424	10	
113608	96	

112476

DART AEROSPACE LTD		Work Order: 52380
Description: PILOTS SIDE INSTRUMENT PANEL		Part Number: ERA-N500-RH
Inspection Dwg:	Rev:	Page 1 of 1

ERA-N500-RH

### FIRST ARTICLE INSPECTION CHECKLIST

☒

First Article

☒

Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
.57	± .030	.568	✓			
1.44	± .030	1.438	✓			
Ø 3.16	+ .012 - .001	3.164	✓			
.88	± .030	.876	✓			
1.15	± .030	1.148	✓			
1.20	± .030	1.194	✓			
3.20	± .030	3.199	✓			
Ø 3.17	+ .012 - .001	3.168	✓			
3.25	+ .030	3.245	✓			
.63	± .030	.635	✓			
Ø .63	+ .008 - .001	.634	✓			
5.20	± .030	5.191	✓			
4.94	± .030	4.935	✓			
.69	± .030	.690	✓			
4.94	± .030	4.935	✓			
4.25	± .030	4.256	✓			
.69	± .030	.693	✓			
.70	± .030	.698	✓			
2.50	± .030	2.499	✓			
.50	± .030	.494	✓			
1.50	± .030	1.498	✓			
1.06	± .030	1.059	✓			
Ø 2.83	+ .012 - .001	2.829	✓			

Measured by: RB
Date: 10-4-6

Audited by: S
Date: 10/6/06

Prototype Approval:
Date:

Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

DART AEROSPACE LTD		Work Order: 57380
Description: PILOTS SIDE INSTRUMENT PANEL		Part Number: ERA-N500-RH
Inspection Dwg:	Rev:	Page 1 of 1

ERA-N500-RH

### FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø 2.30	+0.012 - 0.01	2.300	✓			
2.75	± .030	2.753	✓			
2.82	± .030	2.822	✓			
5.50	± .030	5.502	✓			
6.12	± .030	6.122	✓			
8.75	± .030	8.758	✓			
10.50	± .030	10.502	N			
11.43	± .030	11.433	✓			
13.53	± .030	13.53	✓			
1.88	± .030	1.874	✓			
5.45	± .030	5.450	✓			
7.25	± .030	7.253	✓			
9.00	± .030	9.00	✓			
10.00	± .030	10.00	✓			
11.00	± .030	11.00	✓			
14.50	± .030	14.50	✓			
16.83	± .030	16.83	✓			
17.62	± .030	17.62	✓			
19.25	± .030	19.25	✓			
19.92	± .030	19.92	✓			
21.69	± .030	21.69	✓			
1.88	± .030	1.875	✓			
4.75	± .030	4.750	✓			

Measured by: IB	Audited by: S	Prototype Approval:
Date: 10-4-6	Date: 10/4/06	Date:

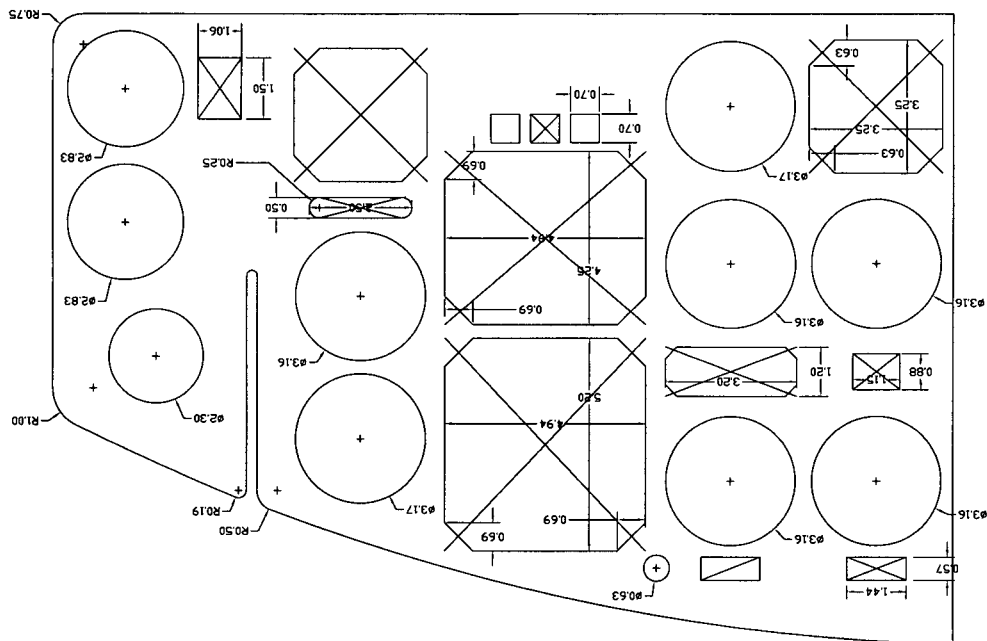
Rev	Date	Change	Revised by	Approved
A		New Issue	KJ/JLM	

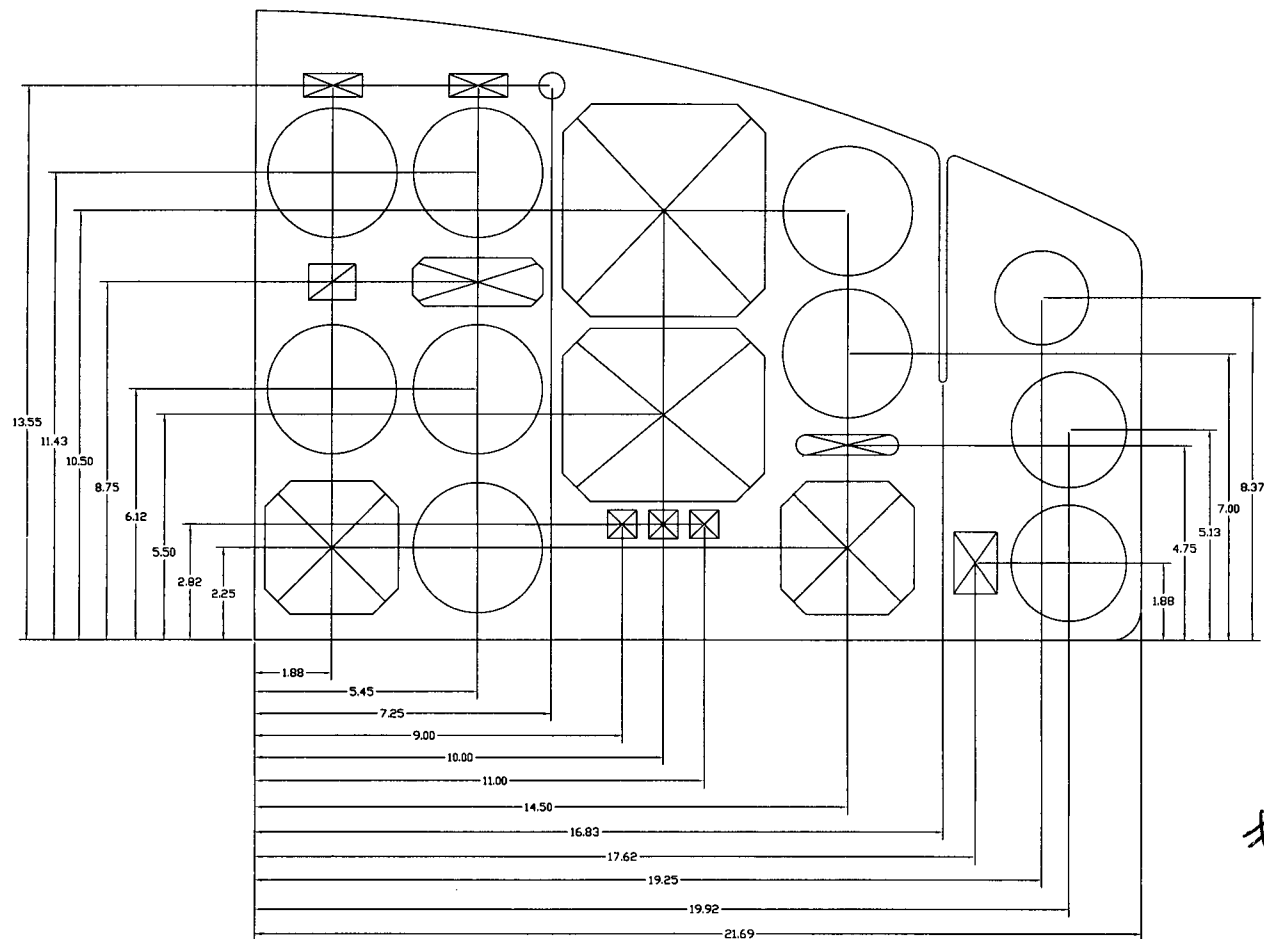


#57380

ERA-N500 - RH

PILOT'S SIDE INSTRUMENT PANEL





PILOT'S SIDE INSTRUMENT PANEL

#57380



## L Lacelle

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**From:** Craig Swayne [cswayne@eaglecopters.com]

**Sent:** April 5, 2010 3:10 PM

**To:** 'L Lacelle'

**Subject:** RE: panels

0.125" thick 2024 T3 or 6061 T6 whichever you have

**Craig Swayne**  
**Project Manager**  
**Eagle Copters**  
**Calgary, Canada**  
**(403) 250-7370**  
**www.eaglecopters.com**



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**From:** L Lacelle [mailto:llacelle@dartaero.com]

**Sent:** Monday, April 05, 2010 12:29 PM

**To:** 'Craig Swayne'

**Subject:** panels

Hi....what thickness are these panels? and what mat;l ? 6061? 2024 ...??

Thank You,  
Linda Lacelle  
Production Manager  
Dart Aerospace Ltd

4/05/10